

# Work Order ID 60231

Tuesday, June 29, 2010 11:42:51 AM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/6/29 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100-

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

304 .040

10-8-19

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-8-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/2019

13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 60231**

Tuesday, June 29, 2010 11:42:51 AM

Page 3

Item ID: D3535-23

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 6/29/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

⇒ M

10/08/27

13

Ø

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: EP-21

0.00

⇒ M

10/08/27

13

4

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/27  
BT/10-8-27  
(13)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 11:42:55 AM

Page 1

Work Order ID: 60231



Parent Item: D3535-23



Parent Item Name: Wearshoe


Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	69.9836	1.3615	14.33158	17.7	10-8-19	

Location

Loc Qty

Loc Code

MAT 66.1278  
114574 66.1278  
MAT20 3.8558  
112885 2.7475  
113062 1.1083  
115389

115389

13

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	10231
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-23
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	*		V HB02	
2.000	+/-0.010	1.999	*		V	
4.750	+/-0.010	4.756	*		T HB01	
9.500	+/-0.010	9.500	*		T	
14.250	+/-0.010	14.250	*		T	
17.750	+/-0.010	17.756	*		T	
23.140	+/-0.010	23.140	*		T	
28.530	+/-0.010	28.536	*		T	
33.920	+/-0.010	33.920	*		T	
39.310	+/-0.010	39.310	*		T	
44.700	+/-0.010	44.706	*		T	
48.200	+/-0.010	48.200	*		T	
52.850	+/-0.010	52.856	*		T	
Ø0.188	+0.005/-0.001	0.192	*		V	
48.00	+/-0.030	48.00	*		T	
39.00	+/-0.030	39.00	*		T	
32.00	+/-0.030	32.00	*		T	
24.00	+/-0.030	24.06	*		T	
16.00	+/-0.030	16.06	*		T	
8.00	+/-0.030	8.00	*		T	
6.00	+/-0.030	6.00	*		T	
0.300	+/-0.010	0.306	*		V	
0.300	+/-0.010	0.306	*		V	
0.038	+/-0.010	0.033	*		V	

<b>Measured by:</b>	RB
<b>Date:</b>	10-8-19

<b>Audited by:</b>	S
<b>Date:</b>	10/08/19

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

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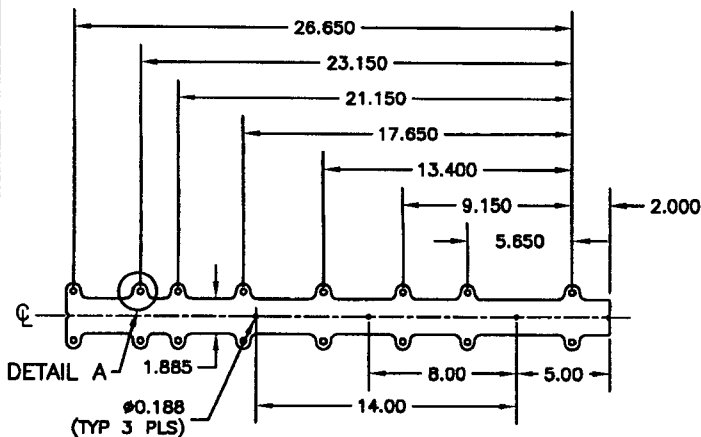
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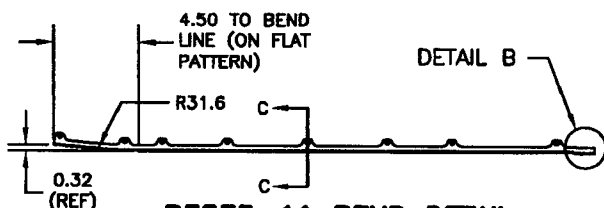
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07.04.24

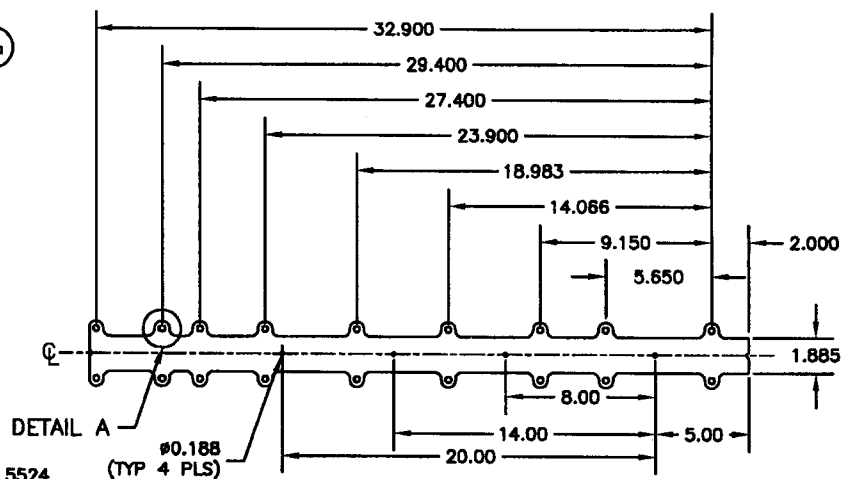
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 66231  
8810-6-29



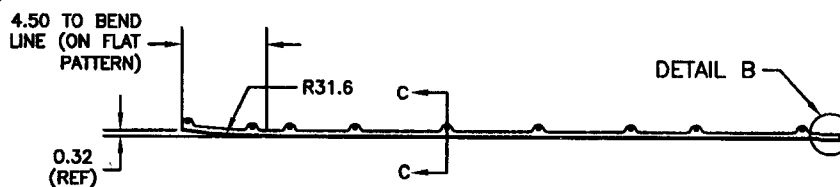
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE	TITLE	WEARSHOE	SCALE	
07.04.17			1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

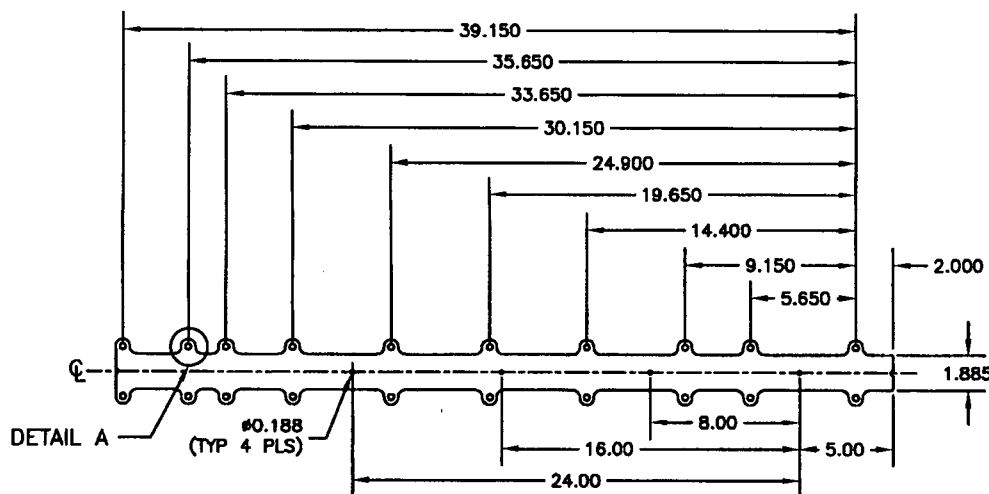
**NOTE:** Date & initial all entries

**DART**

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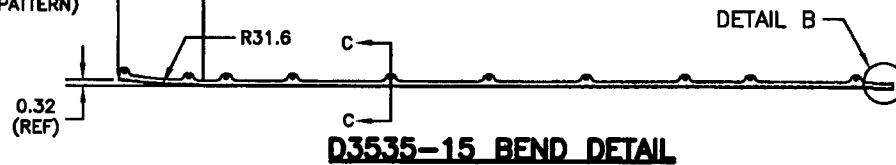
07.04.24 -H

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
DATE	07.04.17	D3535	SCALE
		WEARSHOE	1:10



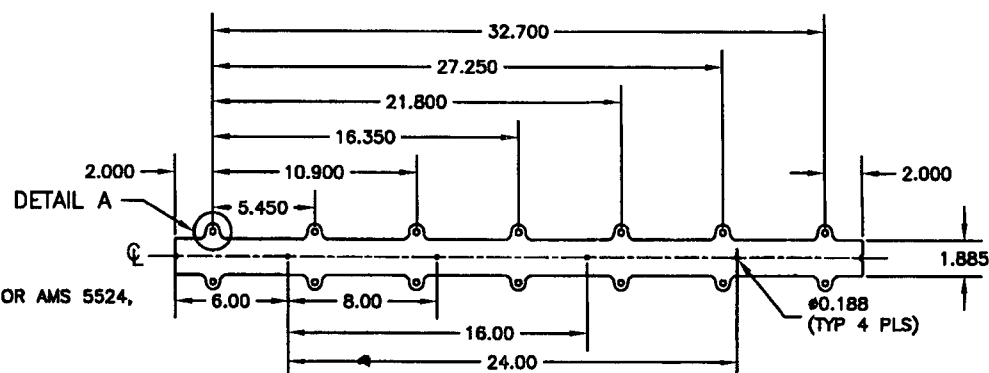
4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

**D3535-15F FLAT PATTERN**

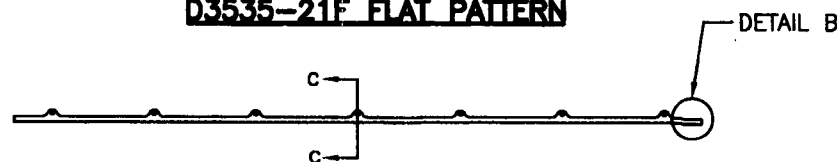


**D3535-15 BEND DETAIL**

w/o 60231



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

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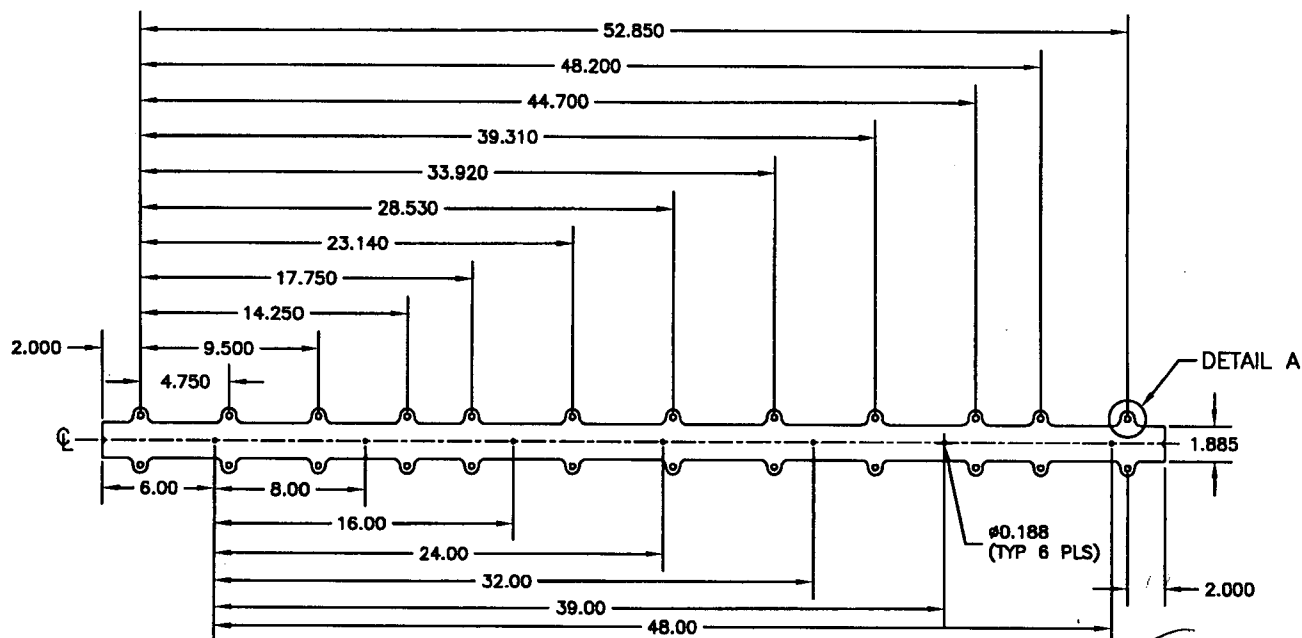
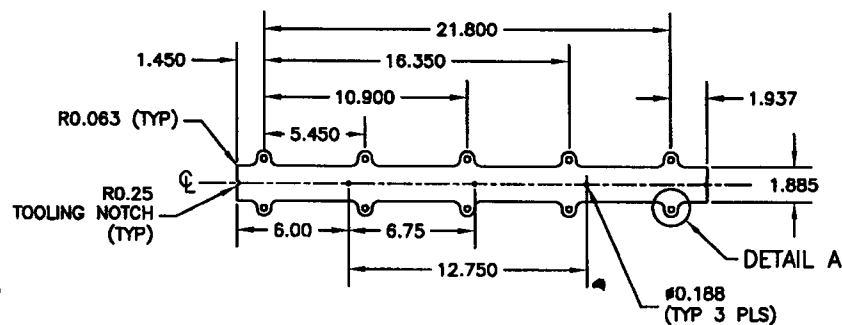
**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 3 OF 7
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:10

RELEASED

07.04.24

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

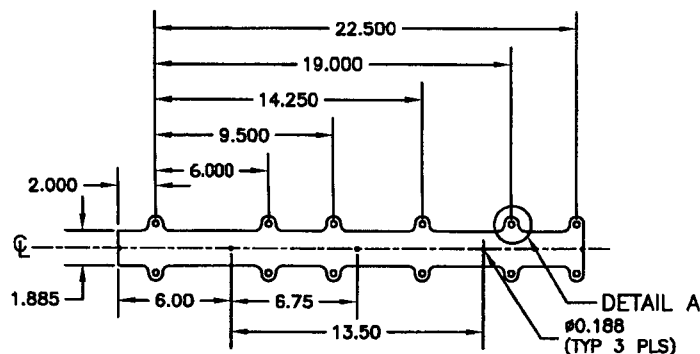
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**NOTE:** Date & initial all entries



**DART**

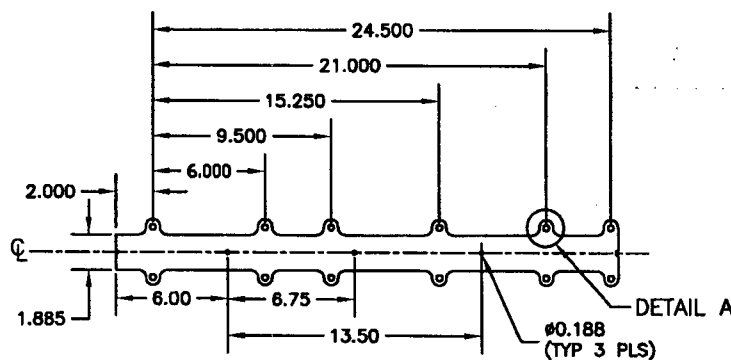
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07.04.24



**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

*WLO 60231*

**NOTES**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	AM	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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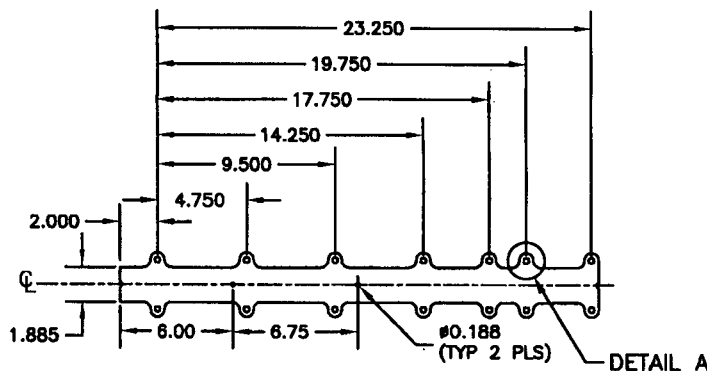
**NOTE:** Date & initial all entries

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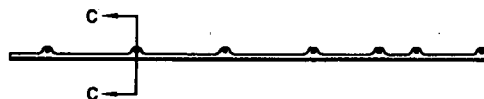
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07.04.17

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
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		SHEET 5 OF 7		
		REV. B		

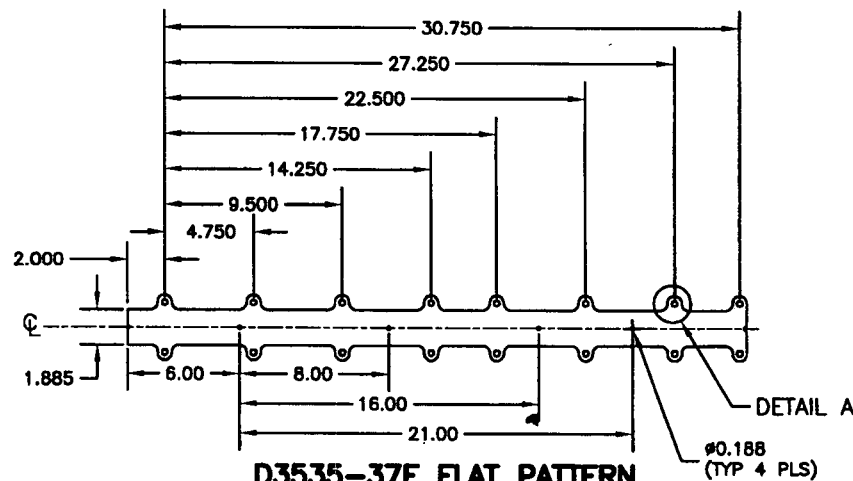


**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**

*w/o 6023)*



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

**NOTES**

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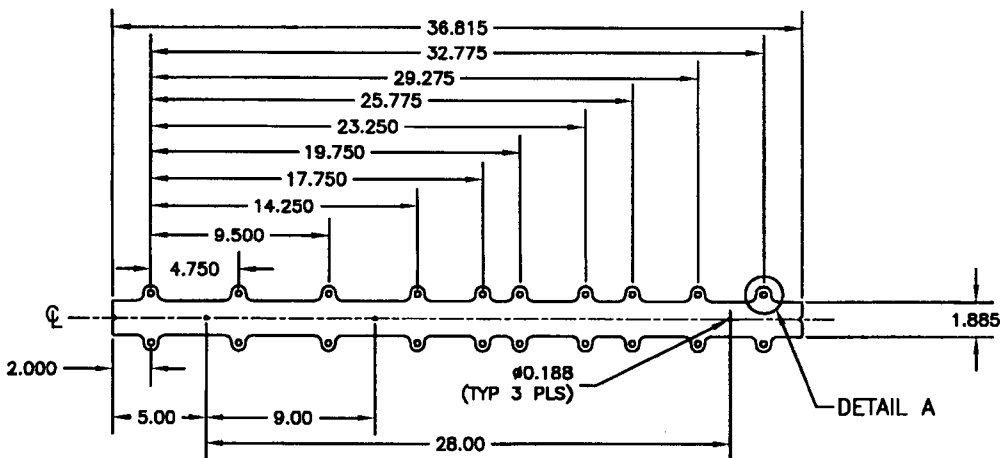
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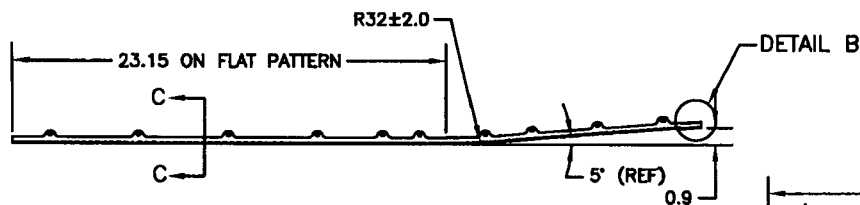
**DART**

RELEASED  
07.04.24

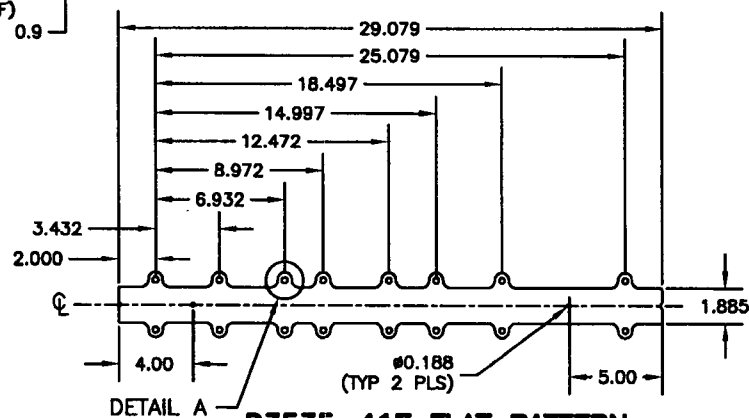
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE
		1:10



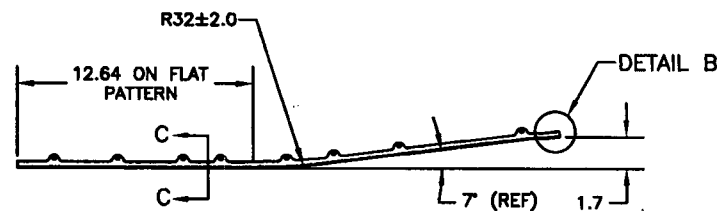
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

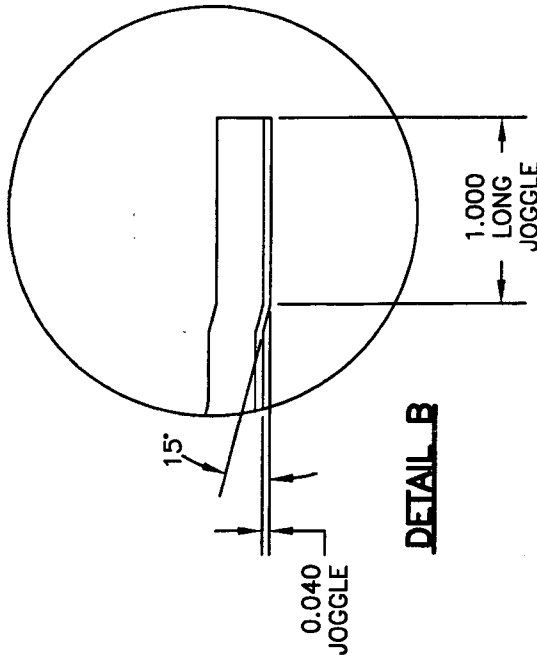
**NOTE:** Date & initial all entries



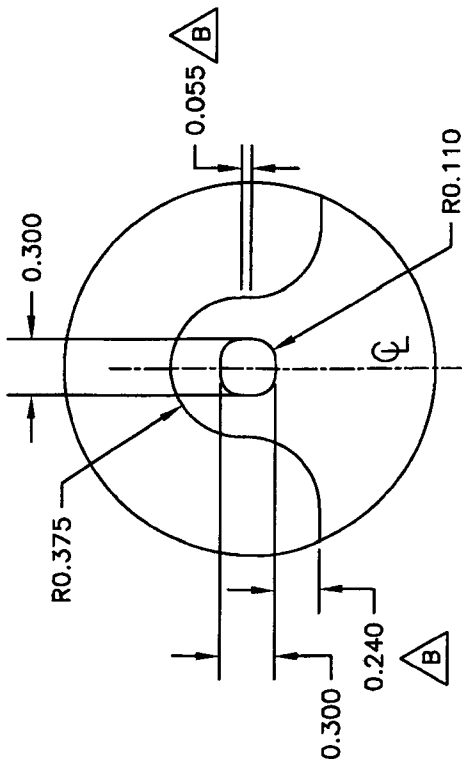
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

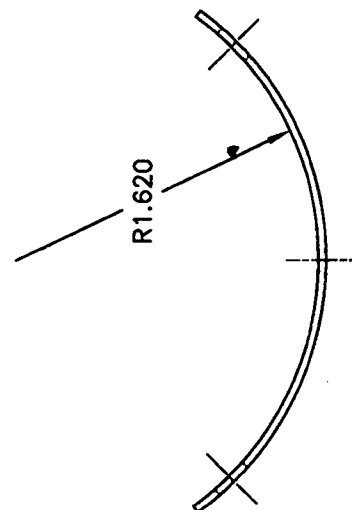
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries